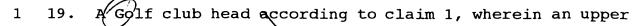
What is claimed is

- 1. A golf club head comprising:
- a cast head body constituted by a hollow outer shell;
- 3 said hollow outer shell defining a top portion, a sole
- 4 portion, a heel wall and a toe portion;
- a shaft securing portion formed adjacent to said heel wall
- 6 and extended from said top portion to said sole portion; and
- 7 a first hollow portion formed between said shaft securing
- 8 portion and said heel wall of said head body.
- 1 2. A golf club head according to claim 1, wherein said hollow
- 2 outer shell defines a face opening portion, a face portion is
- 3 fixed to said face opening portion.
- 1 3. A golf club head according to claim2, wherein a second
- 2 hollow portion is formed between said shaft securing portion
- 3 and said face portion.
- 1 4. A golf club head according to claim 2, wherein said face
- 2 portion is formed by forging.
- 1 5. A golf club head according to claim 2, wherein said face
- 2 portion is formed by press working of a rolled plate member.

- 1 6. A golf club head according to claim 1, wherein a shaft
- 2 securing hole penetrates said shaft securing portion in a region
- 3 from said top portion to said sole portion.
- 1 7. A golf club head according to claim 1, wherein said shaft
- 2 securing hole of said shaft securing portion has a bottom
- 3 portion.
- 1 8. A golf club head according to claim 7, wherein said bottom
- 2 portion is formed in a same surface of said sole portion of
- 3 said head body.
- 1 9. A golf club head according to claim 7, wherein said bottom
- 2 portion of said shaft securing hole has substantially the same
- 3 thickness as the thickness of said sole portion.
- 1 10. A golf club head according to claim 1, wherein said hollow
- 2 outer shell and said shaft securing portion are integrally
- 3 molded with each other by precise casting.
- 1 11. A golf club head according to claim 1, wherein said shaft
- 2 securing portion is formed into a cylindrical shape from said
- 3 top portion to said sole portion.
- 1 12. A golf club head according to claim 1, wherein said first
- 2 hollow portion is formed such that a clearance of 1 mm to 10

- 3 mm is defined between said shaft securing portion and said heel
- 4 wall.
- 1 13. A golf club head according to claim 1, wherein said heel
- 2 wall has a thickness of 0.3 mm to 2 mm.
- 1 14. A golf club head according to claim 1, wherein a width
- 2 of said first hollow portion adjacent to said sole portion is
- 3 wider than a width of said first hollow portion adjacent to
- 4 said top portion.
- 1 15. A golf club head according to claim 1, wherein an edge
- 2 is formed between said sole portion and said heel wall at a
- 3 heel side near than at least said shaft securing portion.
- 1 16. A golf club head according to claim 1, wherein a first
- 2 upper end of the inside portion of said toe portion is higher
- 3 than a second upper end of the inside portion of said heel
- 4 portion in a cross section passing through an axis of said shaft
- 5 securing hole and along said face portion.
- 1 17. A golf club head according to claim 1, wherein a support
- 2 portion connects said shaft securing portion and said heel wall.
- 1 18. A golf club head according to claim 1, wherein a hosel
- 2 portion is formed at said top portion of said head body by
- 3 projecting said shaft securing portion from said top portion.



- 2 end portion of said shaft securing portion is provided lower
- 3 than a top of said top portion.
- 1 20. A golf club head according to claim 1, wherein said head
- 2 body is formed from β -type titanium alloy.
- 1 21. A golf club head according to claim 2, wherein said head
- 2 body is formed from $\alpha\beta$ -type titanium alloy, and said face
- 3 portion is formed from β -type titanium alloy.
- 1 22. A method of manufacturing a cast head body of a hollow
- 2 golf club head including a shaft securing portion extending
- 3 from a top portion to a sole portion and a hollow portion between
- 4 said shaft securing portion and a heel wall, wherein a mold
- 5 piece for forming said hollow portion is interposed between
- 6 portions corresponding respectively to said shaft securing
- 7 portion and said heel wall.
- 1 23. A method of manufacturing a head body of a hollow golf
- 2 club head according to claim 22, wherein said mold piece is
- 3 formed integrally with a lower head body mold member for molding
- 4 an outside of said head body.
- 1 24. A method of manufacturing a head body of a hollow golf
- 2 club head according to claim 22, wherein said mold piece is

- 3 individual from a lower head body mold member for molding an
- 4 outside of said head body.
- 1 25. A method of manufacturing a head body of a hollow golf
- 2 club head according to claim 24, wherein said mold piece
- 3 includes a face mold piece and a back mold piece, said face
- 4 mold piece molds said hollow portion adjacent to a face opening
- 5 portion, and said back mold piece located to a rear side of
- 6 said face mold piece.
- 1 26. A method of manufacturing a head body of a hollow golf
- 2 club head according to claim 24, wherein a hole or a cut portion
- 3 for extracting said mold piece is formed in said head body to
- 4 be manufactured, and said mold piece is extracted in a direction
- 5 through said hole or said cut portion, said direction is
- 6 different from a direction of at least one core for molding
- 7 said head body extracted.
- 1 27. A method of manufacturing a head body of a hollow golf
- 2 club head according to claim 22, wherein said mold piece is
- 3 fractured or dissolved when said mold piece is extracted.
 - 28. A golf club head comprising:
- a head body constituted by a hollow outer shell;
- a shaft securing portion, provided with at least one of
- 4 a top portion and a sole portion, formed by cast,
- 5 the other of said top portion and said sole portion fixed

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- 6 to said one of said top portion and said sole portion;
- 7 wherein a hollow portion is provided between said hollow
- 8 portion and a heel portion.
- 1 29. A golf club head according to claim 28, wherein a joining
- 2 hole, for joining said shaft securing portion, is provided with
- 3 the other of said top portion and said sole portion.

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